


Date: Monday, 3/26/2007 12:25:09 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 31478	
Estimate Number : 12679	
P.O. Number : N/A	Part Number : D35701
This Issue : 3/26/2007 S.O. No. : N/A	Drawing Number : D3570 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run : 30494	Material : N/A
Written By : 	Due Date : 4/2/2007 Qty: 2 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 07-01-30 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.0746 sf(s)/Unit Total : 0.1491 sf(s)

6061-T6 .125 Sheet

Batch: ML 103156ML 07 03 27

(2)

Grain must be Along 4.63**

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3570

Dwg Rev: U/RProg Rev: U/RML 07 03 27

(2)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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ML 07 03 27

(2)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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ML 07 03 27**Comment:** SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3570

N/A

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31478

Part Number: D35701

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

U 07.03.27 R 07.03.27

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

**ENGINEERING
APPROVAL**

NTA

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FOR ENGINEERING USE ONLY

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

FOR ENGINEERING USE ONLY

R 07.03.27

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

Job Completion



6.1 Drill Holes IAW Dwg D3570 and Trim

U 07.03.29
070329

DART AEROSPACE LTD		Work Order: 31478
Description: Bracket		Part Number: D3570-1
Inspection Dwg: D3570 Rev: U/R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.25	+/-0.030	2.253	✓		vern	
B 4.63	+/-0.030	4.63	✓		vern	
C R0.13	+/-0.030	R0.13	✓		Radius Gauge	
D 2.50	+/-0.030	2.50	✓		vern	
E 3.00	+/-0.030	3.00	✓		vern	
F 0.63	+/-0.030	0.610	✓		Height Gauge	
G 1.63	+/-0.030	1.603	✓		Height Gauge	
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: ML/MJ	Audited by: E	Prototype Approval: NTA UB
Date: 07.03.27	Date: 07.03.27	Date: NTA 07.03.27
Rev	Date	Change
		New Issue
		Revised by KJ/RF
		Approved



Alcoa Europe

Fiat Rolled Products
Alcoa Trasformazioni srl
Stabilimento di Fusina
Via dell'Elettronica 31
30030 Malcontenta
Loc. Fusina (Venezia)
Italia
Tel: 39 041 2917111
Fax: 39 041 2917170

149387

INSPECTION CERTIFICATE

EN 10204 3.1

Ordernumber Alcoa 600198001
Date 24/03/2006

AMARI METALS BV
P.O. BOX 1274
3430 BG NIEUWEGEIN NL
NETHERLANDS

Shipment doc.rif. 003820

Vs.ordine nr.
055779DRB23800

Your alloy
6061

Your temper
T6

Quantity
13283 Libbre

Global specification

ALU SHEET 6061 T6
Dimensions T*W*L

B209/AMS QQA
0,1250 x 48,00 x 96,00 Pollici

Remarks

THE PRODUCT MEETS ALL REQUIREMENTS OF:
AMS 4027 AMS QQ-A-250/11 ASTM B209
THE PRODUCT MEETS ALL REQUIREMENTS OF:
AMS 4027 AMS QQ-A-250/11 ASTM B209

Chemical composition

6061

Altro

Cast nr		%Si	%Fe	%Cu	%Mn	%Mg	%Cr	%Ni	%Zn	%Ti	%ognuno	Totale
86018C5	TNT3A	0,74	0,44	0,24	0,070	1,06	0,13	0,0044	0,017	0,015		
Limit	Min.	0,40		0,15		0,80	0,040					
	Max.	0,80	0,70	0,40	0,15	1,20	0,35		0,25	0,15	0,050	0,15

Mechanical properties

Coil nr:		Rm	Rp0.2	A50
	Pallet	KSI	KSI	%
TNT3A		48	41	16
TNT3A		47	41	14
	0531817			
	0531818			
	0531819			
	0531820			
	Min.	42	35	10
	Max.			

Approved by
R. Signori Test.Lab.Supervisor

We hereby certify, that the material described above has been tested and complies with the terms of the confirmation of order.